

WHAT IS CLAIMED IS:

1. A multilayer film comprising:

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- a) a first and second outer layer each comprising a polymer;
  - b) a core layer comprising a polymer; and
  - c) a first and second substrate layer each comprising a polymer, the first and second substrate layers disposed between the core layer and the first and second outer layers respectively;

10 wherein at least one of the first and second substrate layers comprises an amidic wax; and

wherein at least one of the first and second outer layers comprises an amidic wax, the amidic wax present in an amount of 1% to 50% of the amount of wax in the first and second substrate layers respectively.

15 2. The film of claim 1 wherein the first and outer layers, the core layer, and the first and second substrate layers, each comprises a polymer selected from the group consisting of:

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- a) ethylene/alpha olefin copolymer;
  - b) ethylene/vinyl acetate copolymer;
  - c) ionomer resin;
  - d) ethylene/ acrylic or methacrylic acid copolymer;
  - e) norbornene/ethylene copolymer
  - f) polystyrene
  - g) ethylene/styrene copolymer
  - 25 h) propylene homopolymer or copolymer
  - i) ethylene/ acrylate or methacrylate copolymer; and
  - j) polyethylene.

30 3. The film of claim 1 wherein the amidic wax of the at least one of the first and second substrate layers, and of the at least one of the first and second outer layers, comprises a material selected from the group consisting of:

- a) primary amide,
- b) secondary amide,
- c) tertiary amide, and

d) N,N'-bis(fatty acid) amide.

4. The film of claim 1 wherein the first and second outer layers each comprises an antiblock agent.

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5. The film of claim 1 wherein the film exhibits an Elmendorf Tear value (ASTM D 1922-94A) of more than 25 grams per mil.

6. The film of claim 1 wherein the film is heat shrinkable.

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7. A multilayer film comprising:

- a) a first and second outer layer each comprising a polymer;
- b) a core layer comprising a polymer; and
- c) a first and second substrate layer each comprising a polymer, the first and second substrate layers disposed between the core layer and the first and second outer layers respectively;

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wherein at least one of

- i) the first substrate layer,
- ii) the second substrate layer,
- iii) the first outer layer, and
- iv) the second outer layer,

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comprises a blend of

- i) amidic wax, and
- ii) transition metal salt of stearic acid, or ester of stearic acid.

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8. The film of claim 7 wherein the first and outer layers, the core layer, and the first and second substrate layers, each comprises a polymer selected from the group consisting of:

- a) ethylene/alpha olefin copolymer;
- b) ethylene/vinyl acetate copolymer;
- c) ionomer resin;
- d) ethylene/ acrylic or methacrylic acid copolymer;
- e) ethylene/ acrylate or methacrylate copolymer; and
- f) low density polyethylene.

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9. The film of claim 7 wherein the amidic wax comprises a material selected from the group consisting of:

- 5           a) primary amide,  
          b) secondary amide,  
          c) tertiary amide, and  
          d) N,N'-bis(fatty acid) amide.

10       10. The film of claim 7 wherein the transition metal salt of stearic acid comprises zinc stearate.

11. The film of claim 7 wherein the first and second outer layers each comprises an antiblock agent.

15       12. The film of claim 7 wherein the film exhibits an Elmendorf Tear value (ASTM D 1922-94A) of more than 25 grams per mil.

13. The film of claim 7 wherein the film is heat shrinkable.

20       14. A multilayer film comprising:

- a) a first and second outer layer each comprising a polymer; and  
          b) a substrate layer comprising a polymer; and

          wherein at least one of

- 25           i) the first outer layer,  
          ii) the second outer layer, and  
          ii) the substrate layer,

          comprises a blend of

- i) amidic wax, and  
          ii) transition metal salt of stearic acid, or ester of stearic acid.

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15. The film of claim 14 wherein the first and outer layers, and the substrate layer, each comprises a polymer selected from the group consisting of:

- a) ethylene/alpha olefin copolymer;  
          b) ethylene/vinyl acetate copolymer;

- c) ionomer resin;
- d) ethylene/ acrylic or methacrylic acid copolymer;
- e) ethylene/ acrylate or methacrylate copolymer; and
- f) low density polyethylene.

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16. The film of claim 14 wherein the amidic wax comprises a material selected from the group consisting of:

- a) primary amide,
- b) secondary amide,
- c) tertiary amide, and
- d) N,N'-bis(fatty acid) amide.

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17. The film of claim 14 wherein the transition metal salt of stearic acid comprises zinc stearate.

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18. The film of claim 14 wherein the first and second outer layers each comprises an antiblock agent.

19. The film of claim 14 wherein the film exhibits an Elmendorf Tear value (ASTM D 1922-94A) of more than 25 grams per mil.

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20. The film of claim 14 wherein the film is heat shrinkable.